

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005672**Date Inspected:** 17-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Jin Dong Liang, Li Hong Fei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 10

This QA Inspector also randomly observed the following work in progress in Bay 10:

FCAW welding of weld joints NSD1-SA61F/G-2, 3 and E/G-2, 3 located on PCMK north tower, lift 2, skin E.

Welders were identified respectively as 067752, 063869, 068501, and 066683. ZPMC QC was identified as Jin Dong Liang (QC1). The welding variables recorded by QC1 appeared to comply with the WPS:

B-T-2332-Tc-P5-F. Also present at this location and appearing to observe the welding operation was ABF

Representative Yang Yi Heng (ABF1).

FCAW welding of weld joints NSD1-SA163A/D-17, 18 located on PCMK north tower, lift 3, skin B. Welders were identified respectively as 040457 and 067499. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with the WPS: B-T-2332-Tc-P5-F. Also present at this location and appearing to observe the welding operation was ABF1.

Bay 11

This QA Inspector also randomly observed the following work in progress in Bay 11:

FCAW welding of weld joints WSD1-SA388A/D-30, 31 located on PCMK west tower, lift 2, skin C. Welder at both locations was identified as 203793. ZPMC QC was identified as Li Hong Fei (QC2). The welding variables recorded by QC2 appeared to comply with the WPS: B-T-2332-Tc-P5-F.

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SAW welding of weld joint ESD1-A165C/J-264A located on PCMK east tower, lift 1, skin A to skin E. Welder was identified as 056975. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with the WPS: B-T-2221-C-U2b-S. Also present at this location and appearing to observe the welding operation was ABF Representative You Yuan Mao (ABF2).

SAW welding of weld joint ESD1-A165C/J-264B located on PCMK east tower, lift 1, skin A to skin E. Welder was identified as 042195. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with the WPS: B-T-2221-C-U2b-S. Also present at this location and appearing to observe the welding operation was ABF2.

Summary of Conversations:

This QA inspector asked both QC's noted above if all the welding variables observed by them appeared to comply with the appropriate WPS, including preheat and interpass temperature requirements according to thickness of the thickest member being welded. Each QC showed this QA Inspector that he was carrying the appropriate temperature sticks to monitor the minimum and maximum preheat and interpass temperatures and replied that all he observed did appear to comply.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
